



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3065-3

Job Sheet 170993



Part No: D3065-3

Job Qty: 80 ea

Part Name: Step Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/25/18

Job Tracking No:

Due Date: 2/6/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	80 Ea		2/5/18	0.00	0.00	Start Up Waterjet		18-01-28
100	Waterjet	80 pcs		2/5/18	0.00	3.69	Waterjet1		18-01-28
120	QC	80 pcs		2/5/18	0.00	0.00	QC8		18-01-28
140	Brake NC	80 pcs		2/5/18	0.02	3.76	Brake NC 1		18-01-28
150	QC	80 pcs		2/5/18	0.00	0.00	QC5		18-01-28
160	HandFinish	80 pcs		2/6/18	0.00	1.63	HandFinish1		18-01-28
170	QC	80 pcs		2/6/18	0.00	0.00	QC7-1		18-01-28
180	Packaging	80 pcs		2/6/18	0.00	0.00	Packaging3-1		18-01-28
190	QC21-SA	80 Ea		2/6/18	0.00	0.00	QC21		18-01-28

Part Op 100 - 1-Cut as per Dwg Rev: B

Descriptions: 140 - Bend as per Dwg D3065

180 - LOCATION : GA

FEB 02 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	17.4240 sf (.2178 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	17	96	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		 S036292 Step Spacer Start up Operation 01/29/18 Job No: 170993											
Description Work Order Deviation 		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%; text-align: center;"> ☐ Engineering ☐ Quality ☐ Other </td> <td style="width: 50%; text-align: center;"> ☐ ☐ ☐ ☐ </td> </tr> <tr> <td colspan="2" style="text-align: center;">MRB (QSI042) Approval</td> </tr> <tr> <td colspan="2" style="text-align: center;">Completed By</td> </tr> <tr> <td colspan="2" style="text-align: center;">Lead hand / Supervisor Approval Verification</td> </tr> <tr> <td colspan="2" style="text-align: center;">QC / QA Coordinator Approval</td> </tr> </table>		☐ Engineering ☐ Quality ☐ Other	☐ ☐ ☐ ☐	MRB (QSI042) Approval		Completed By		Lead hand / Supervisor Approval Verification		QC / QA Coordinator Approval	
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QC / QA Coordinator Approval															
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OTHER : ☐		☐ Fit/Function ☐ Misaligned/off center													

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	1.260inches $\pm$ 0.010	1.270 1.250		
2	Step Spacer	3.260inches $\pm$ 0.010	3.270 3.250		
3	Step Spacer	5.260inches $\pm$ 0.010	5.270 5.250		
4	Step Spacer	6.520inches $\pm$ 0.010	6.530 6.510		
5	Step Spacer	2.093inches $\pm$ 0.010	2.103 2.083		
6	Step Spacer	3.936inches $\pm$ 0.010	3.946 3.926		
7	Step Spacer	4.186inches $\pm$ 0.010	4.196 4.176		
8	Step Spacer	0.129inches + 0.005 - 0.000	0.134 0.129		
9	Step Spacer	1.250inches + 0.005 - 0.000	1.255 1.250		
10	Step Spacer	1.204inches $\pm$ 0.005	1.209 1.199		
11	Step Spacer	0.040inches $\pm$ 0.010	0.050 0.030		

Plex 1/25/18 12:20 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

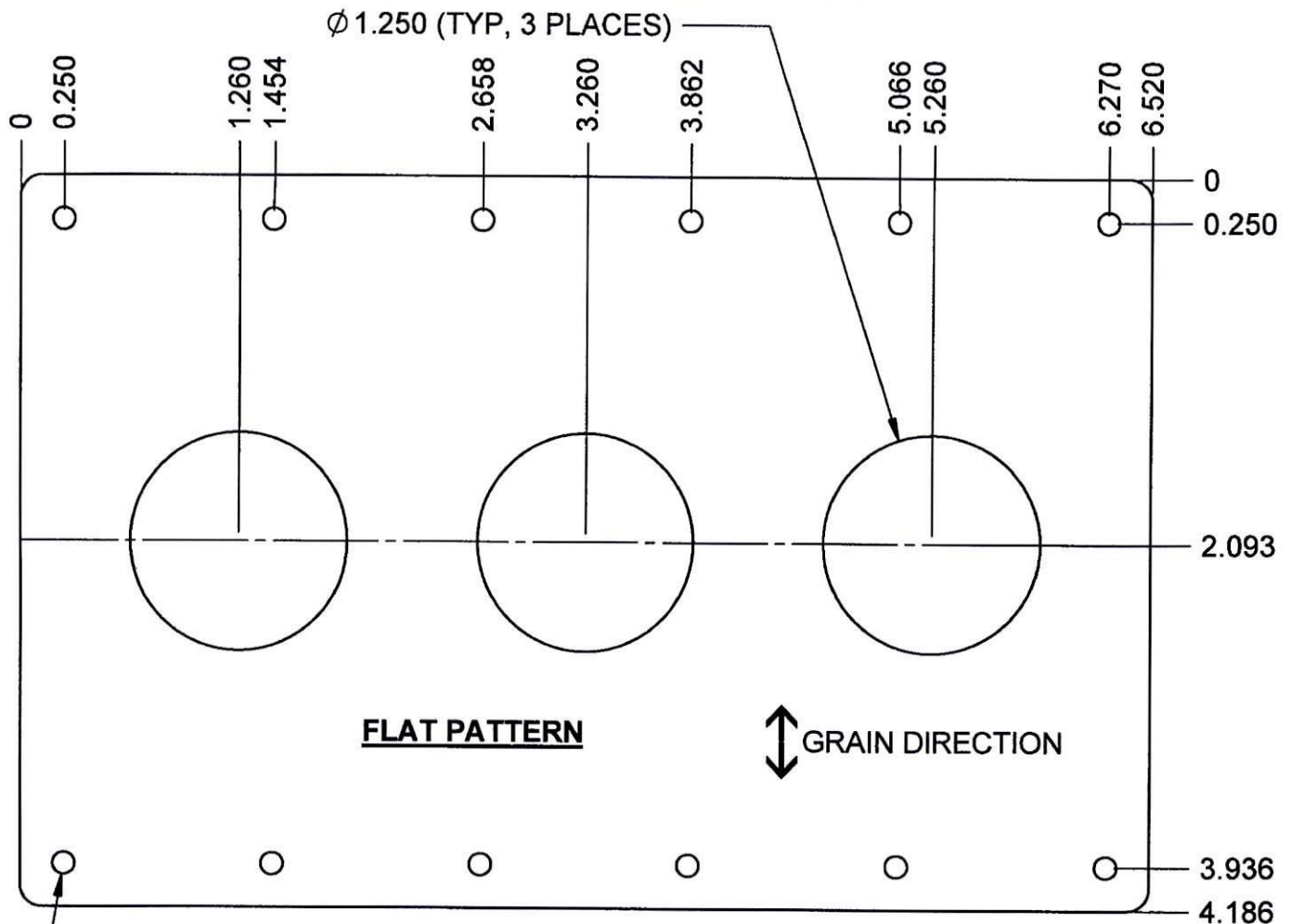
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

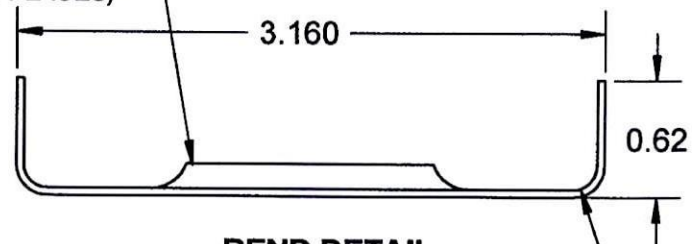


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

$\phi 0.129$ (TYP, 12 PLACES)

RELEASED

06.05.23



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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